

Work Order ID 48085

July 1, 2009 2:17:46 PM



Page 1

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start



Stop



Start Date: 07/15/2009 Start Qty: 1.00
Required Date: 08/03/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut tube to finish length as per Dwg D3391 12-Identify as D3391-023 13-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391 14-Open saddles and GHW holes to Ø0.375" except for fwd saddle

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 48085

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Page 2

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open float bag holes as per dwg 112-C'sink float bag holes as per dwg 113-
Prepare tube for welding 114-Bond web in place as per Dwg D3391 & QSI
015.11Adhere for 12 hours)



150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



Work Order ID 48085

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Page 3

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Weld crossbolt spacer as per dwg D3391 & QSI 004 12-grind weld flush ✓

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Work Order ID 48085

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Page 4

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start



Stop



Start Date: 07/15/2009 Start Qty: 1.00
Required Date: 08/03/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ FINISH TIME: _____	0.00 0.00		✓					
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		✓					
210 Skidtubes Skidtubes	Skidtubes Memo 1- insert D3391-021 into D3391-23 2- insert T-pins into first and third fwd saddle holes 3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364 4- remove T-pins and locate DT9415 from first and third crossbolt hole using	0.00 0.00		✓					

Work Order ID 48085

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Page 5

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

230

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg

BR/mmp 09/07/06

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 09/06/06

①

②

Work Order ID 48085

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Page 6

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

260

QC21- Final Inspection - Work Order Release

0.00

09/08/25 HJ



09-8-25



QC

Memo

0.00

Quality Control

Picklist Print

July 1, 2009 2:17:45 PM

Page 1

Work Order ID: 48085

Parent Item: D3391-023RevH

Parent Item Name: Mid Tube Assembly

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ ALS4-1032-130		Purchased	No			100	Each	7,849.000	22.0000			
-----------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7849

(110511) (K20)

7849

✓ D3391-021RevH		Manufactured	No			140	Each	0.0000	1.0000			
-----------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Fwd Tube Assembly

✓ D3681-1RevA		Manufactured	No			210	Each	74.0000	5.0000			
---------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Spacer

see
attach!
cross w/o

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

74

47123

13

48178

61

MD 09/07/06

pulled on w/o 51346
742045

Picklist Print

July 1, 2009 2:17:45 PM

Work Order ID: 48085

Parent Item: D3391-023RevH

Parent Item Name: Mid Tube Assembly



Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3591-1RevB ✱ 		Manufactured	No			230	Each	79.0000	2.0000			
Bushing												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43172

46105

47121

79

6

29

44

MD 09/07/00

Date: Wednesday, 20/05/2009 1:09:59 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MID TUBE ASSEMBLY
Job Number :	48085		
Estimate Number :	10469		
P.O. Number :		Part Number :	D3391023
This Issue :	20/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3391 REV H
First Issue :	/ /	Project Number :	N/A
Previous Run :	48084	Drawing Revision :	H
Written By :		Material :	
Checked & Approved By :	<u>Julie Dawson</u>	Due Date :	29/05/2009
Comment :	Est. A 05.10.20 New Issue KJ/EC Est. B 06.02.10 ECN773 dwg rev.D EC est C 07.03.20 rev F dwg EC est D 07.03.28 re-format EC est E 07.10.31 ecn 1053P EC Est Rev:F ECN 1056 07-11-13 DD verified by: EC Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC Est Rev:H 08-09-10 revH as per dwg DD verified by:EC Est Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec		
Qty:	1	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

B 24593 D M 9-5-21

2.0	D3391021	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: B 47307

D M 9-5-21

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as

M 9-5-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:09:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DA-R001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48085

Part Number: D3391023

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drillol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5015122 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:09:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48085

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

✓

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-5-22 (1)

6.0

✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD 9-5-22

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

B-47303

A/R

Sikaflex-241/-291

M 111081

Sikaflex expire date:

01-20-10

Start: 9-5-22

Time: 10:15

Finish: 9/5/22

Time: 8:00am

AWM 9-5-22 (1)

8.0

✓

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open float bag holes to 0.313"

2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

AWM 9-5-22

9.0

✓

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80910/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:09:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48085

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

✓ D36811

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

SPACER

batch: B 46107 (1) B 47123 (4) BE 09/05/28

11.0

✓ SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld crossbolt spacer as per dwg D3391 & QSI 004

2-grind weld flush fm 09-05-29 (1) BE 09/05/28

12.0

✓ QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

13.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

✓ POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:35

OVEN TEMPERATURE: 320°

FINISH TIME: 11:05

15.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

✓ D35911

Bushing





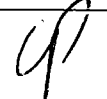

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing B 43772 MD 09/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.08.18	17	Fwd saddle hole, bushing not aligning with other side RC Process	 09.08.18 per PS/042	Acceptable to file inner hole to allow bushing install. Touch up with elodine	HJ 09-08-18 	 09.08.18 per PS/042	 09.08.18 per PS/042	S 09/08/18

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:09:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48085

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

- ✓ 1- insert D3391-021 into D3391-23
- 2- insert T-pins into first and third fwd saddle holes
- ✓ 3- ON-FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364
- ✓ 4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos
- ✓ 5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415
- ✓ 6- deburr, re-alodine and blow out chips
- ✓ 7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

all 09-08-18 (X1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 05/05/20 (X1)

19.0

ALS41032130

Insert



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

INSERT

batch: _____

or equivalent

per QSI 017

m 110511 (x20)

uno 09/07/06

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ Install Inserts as per Dwg

bl /mo 09/07/06

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 05/05/20 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:09:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 48085

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 5141.3

10/9/14

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

~~10/9/14~~

Job Completion



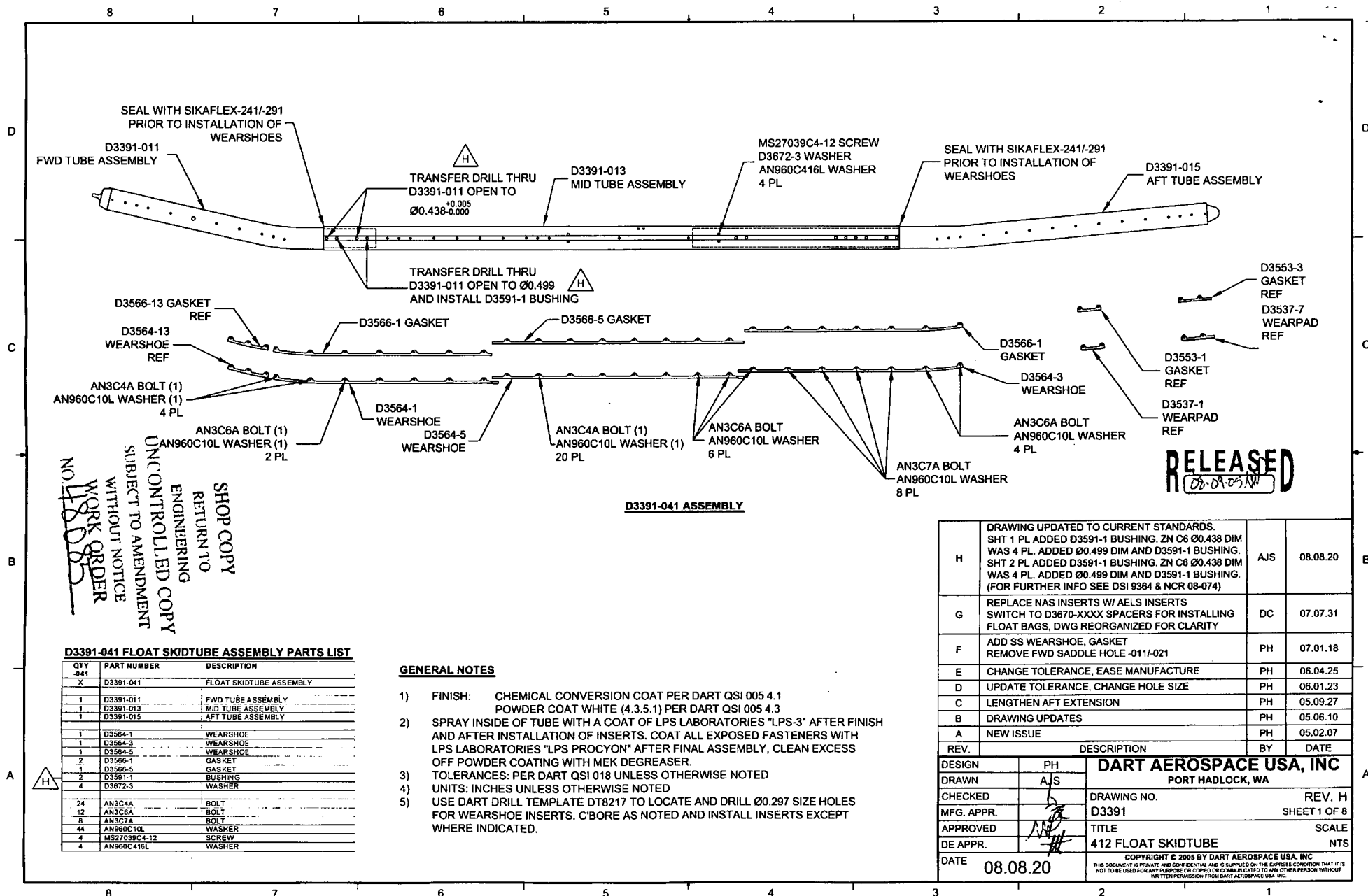
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

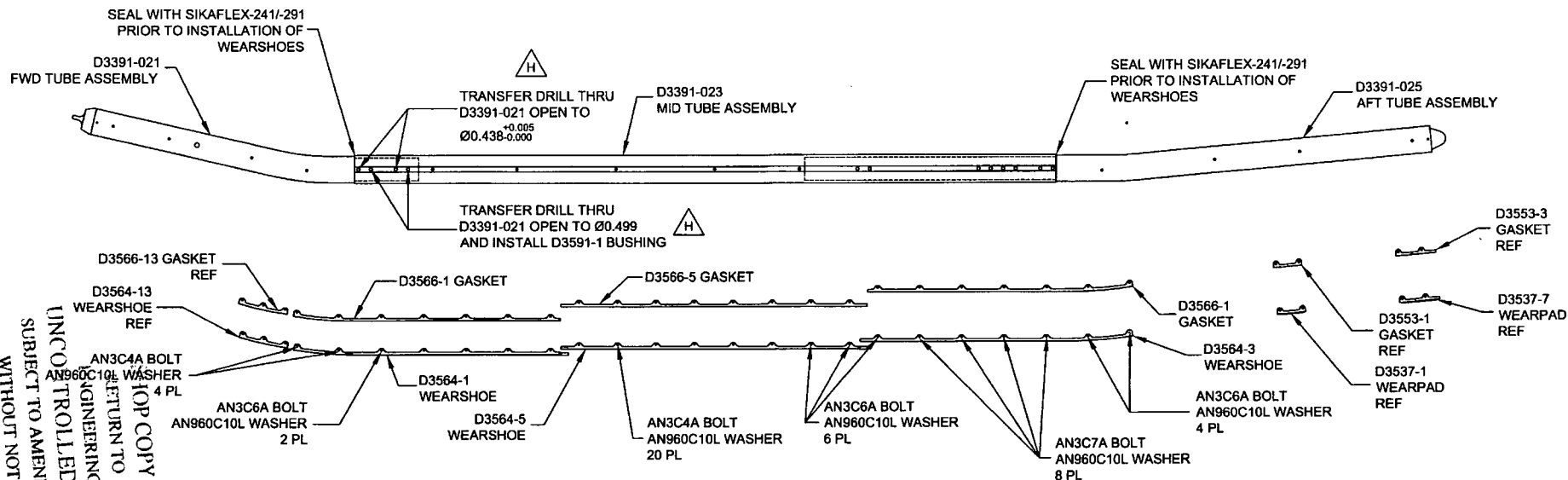
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)		AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY		DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021		PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE		PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE		PH	06.01.23
C	LENGTHEN AFT EXTENSION		PH	05.09.27
B	DRAWING UPDATES		PH	05.06.10
A	NEW ISSUE		PH	05.02.07
REV.		DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. REV. H D3391 SHEET 1 OF 8 TITLE SCALE 412 FLOAT SKIDTUBE NTS DATE 08.08.20		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE CUSTOMER/CONTRACTOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION/DISAGREE AFTERNOON USE INC		



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

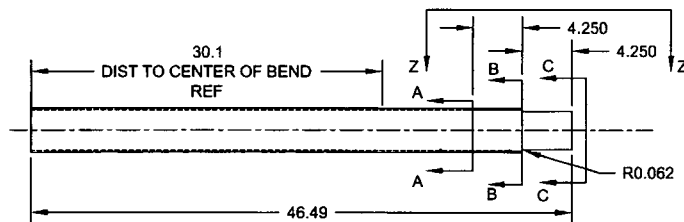
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

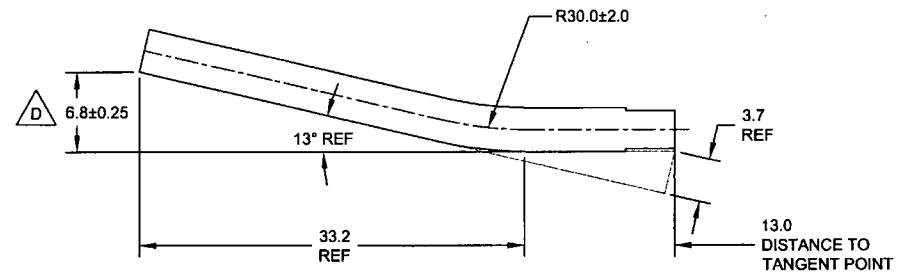
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

RELEASED
08-09-05/10

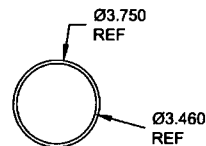
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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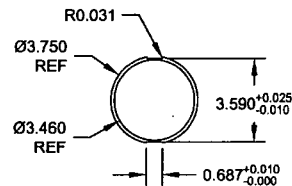
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



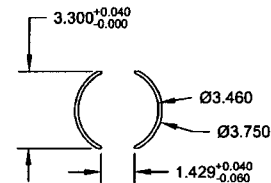
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



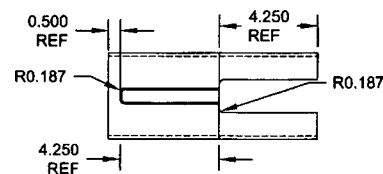
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

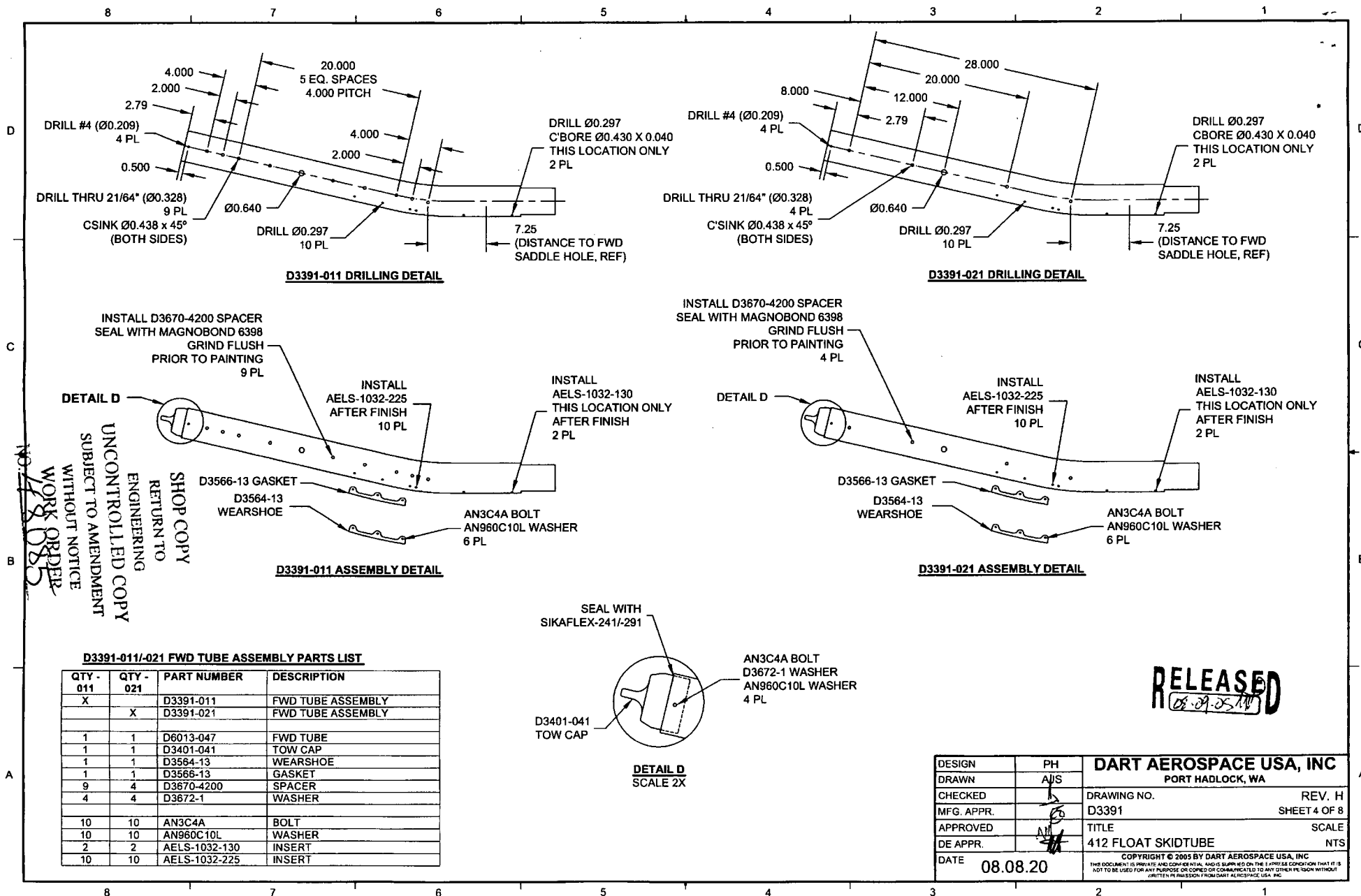


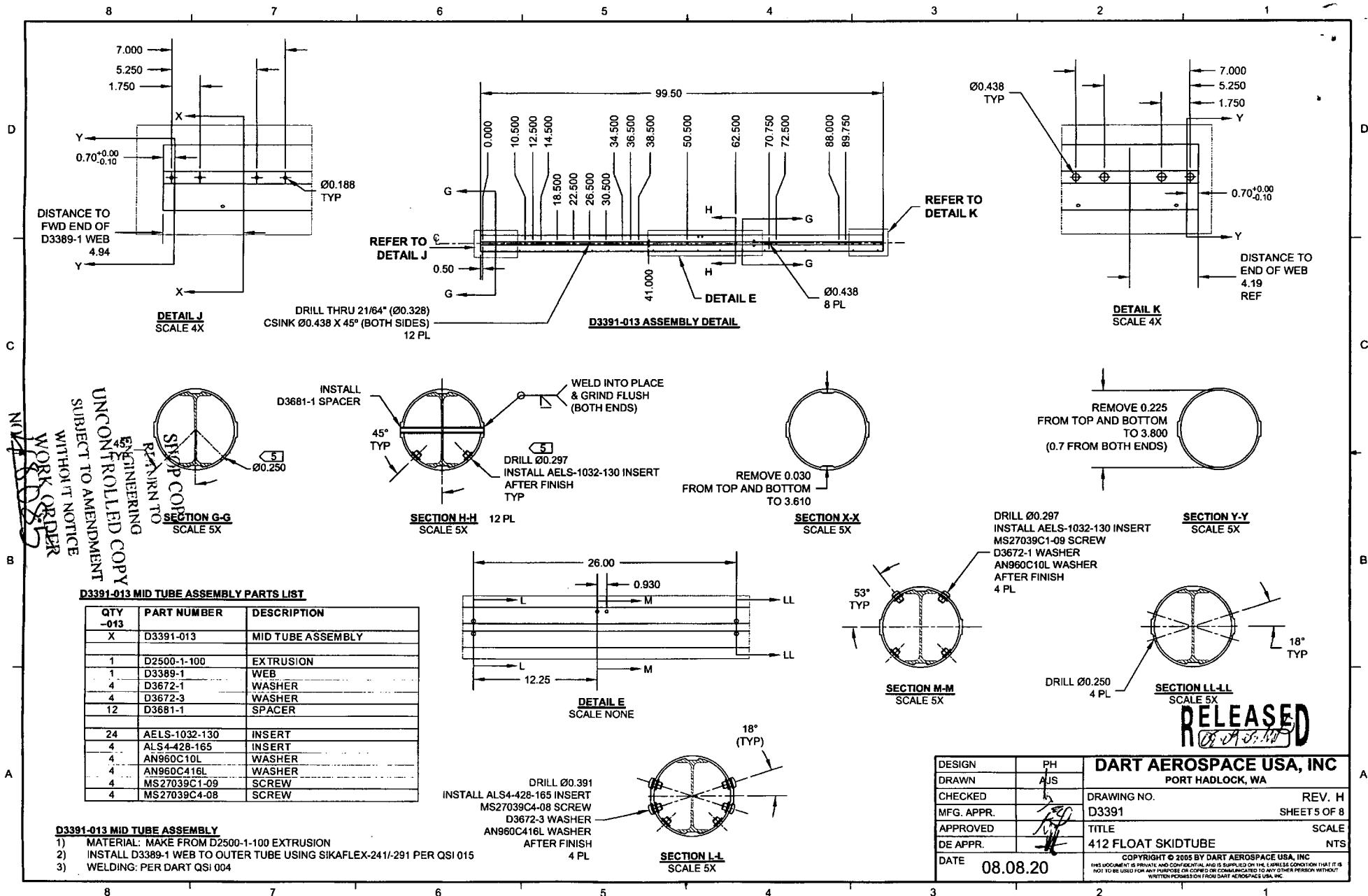
VIEW Z-Z
SCALE 2X

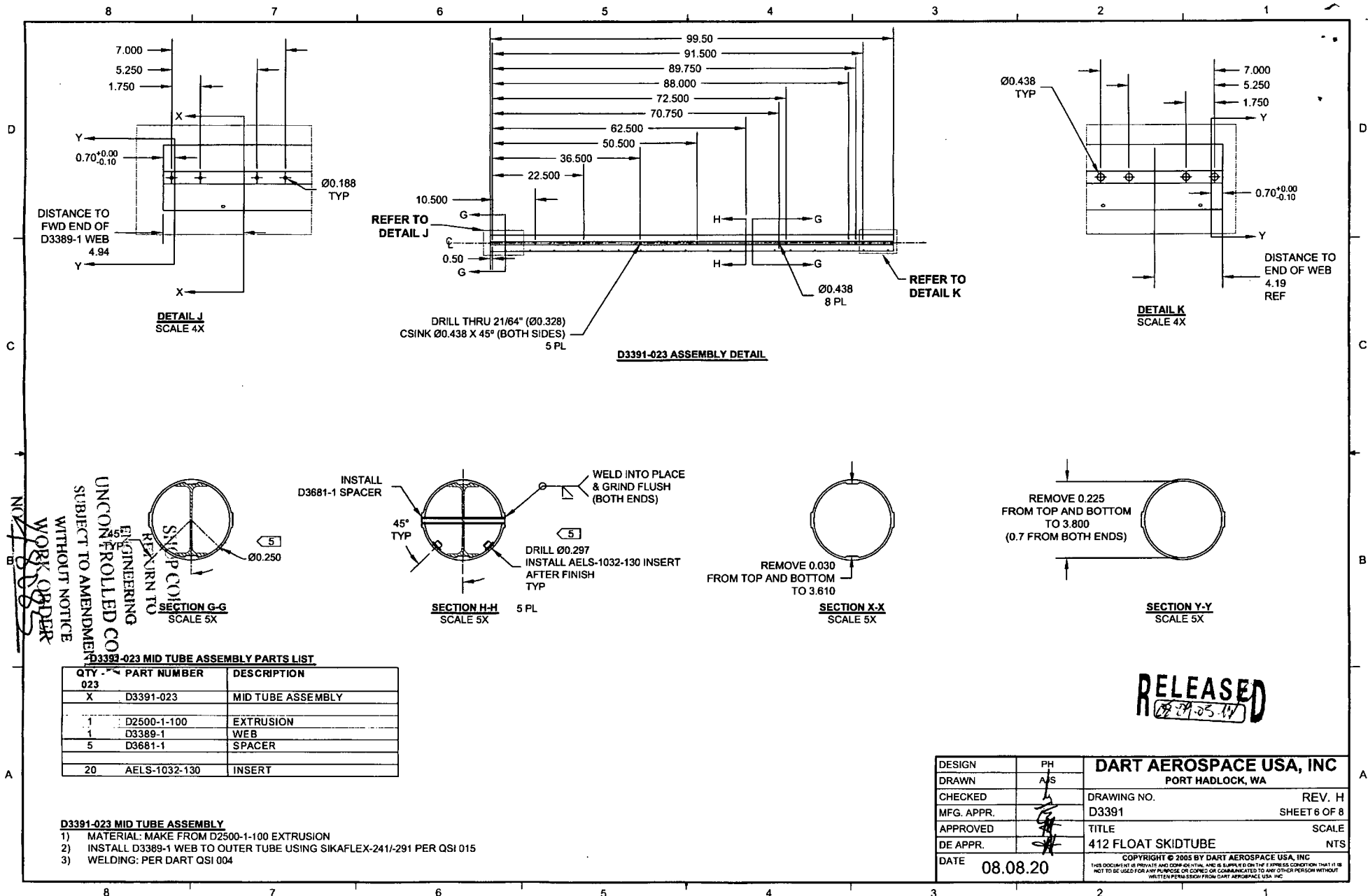
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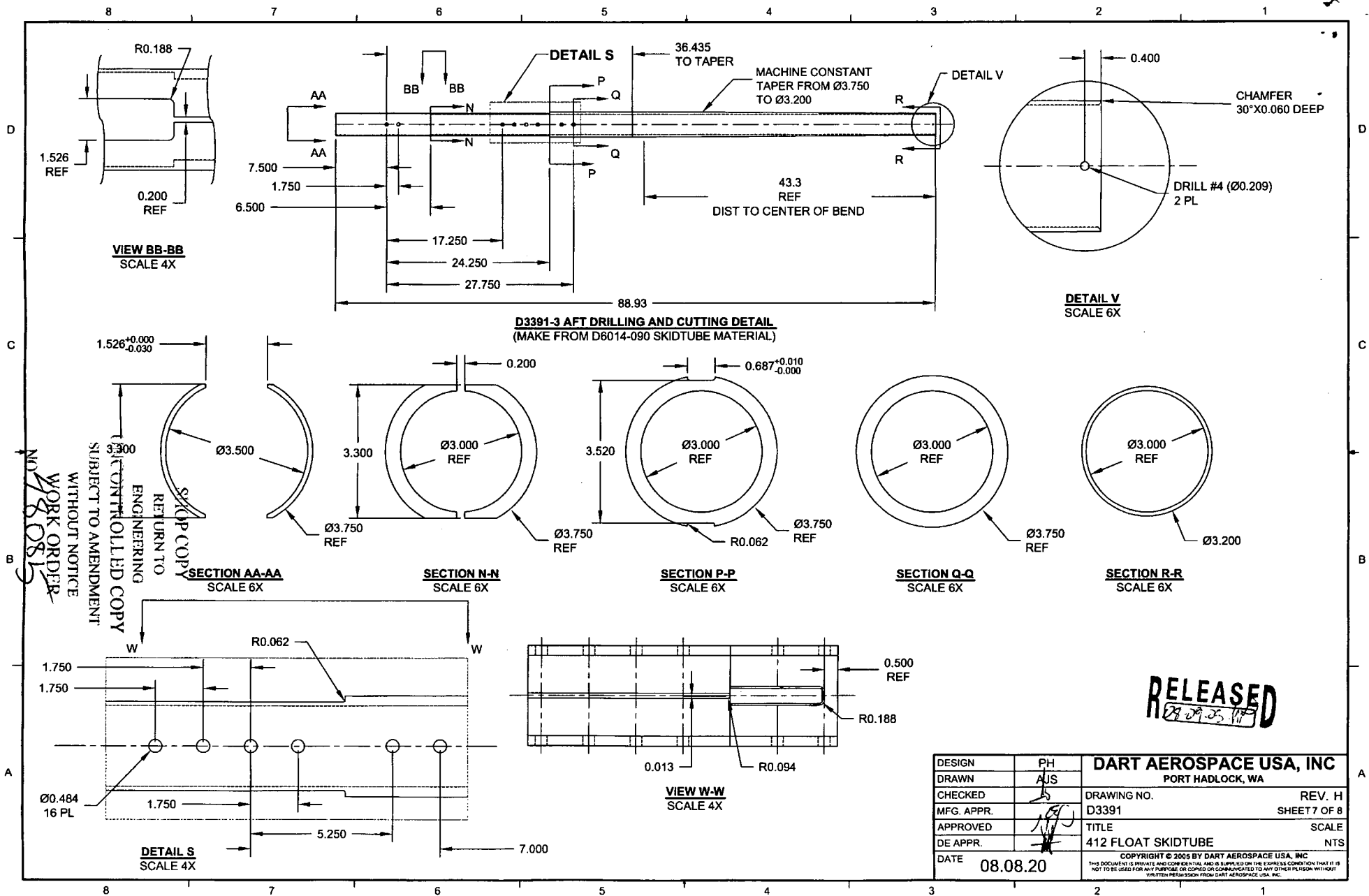
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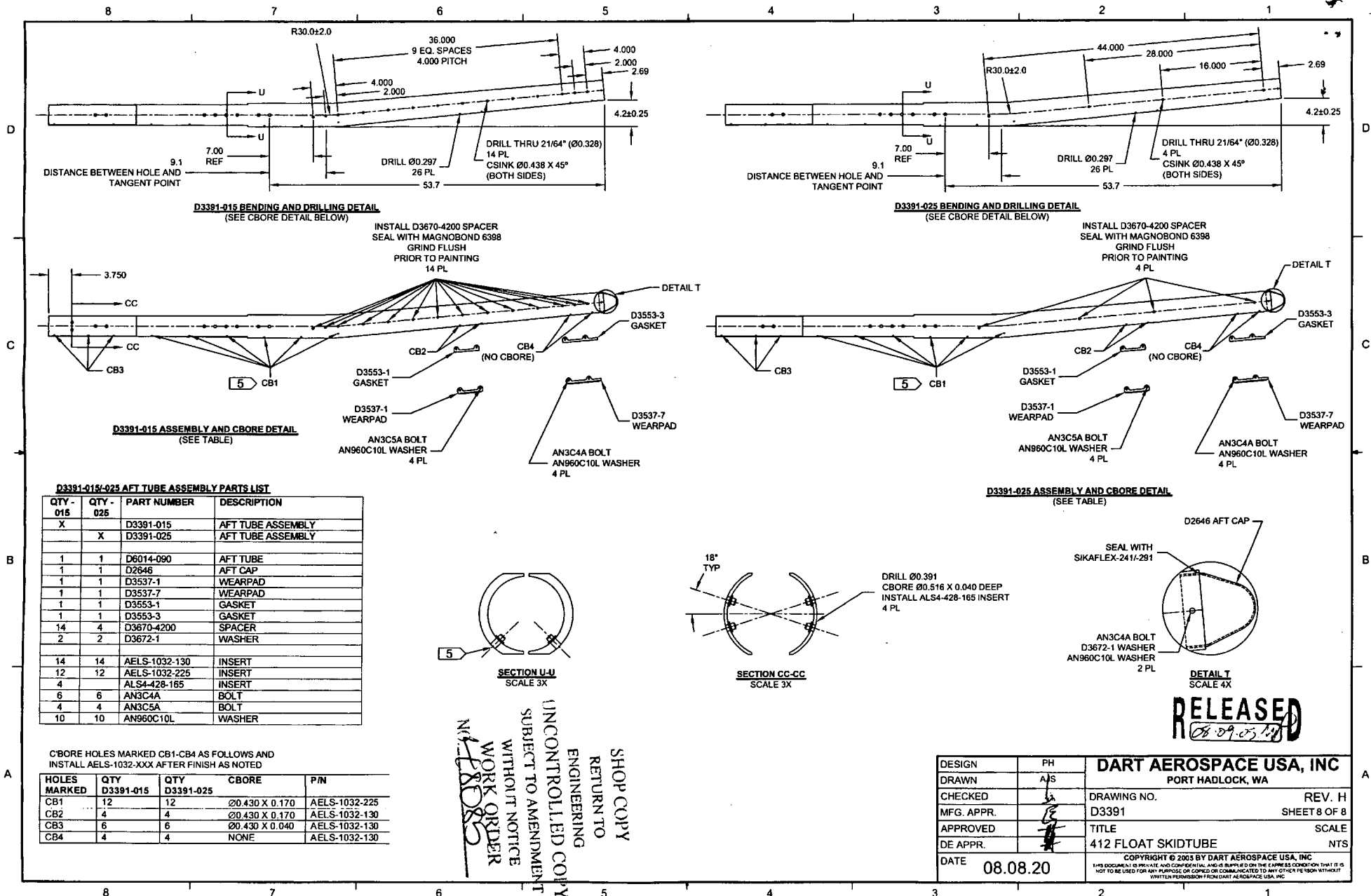




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NO. 200

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 48045
Part number: D3391 033
Description: Mid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Barclay Elliott

Date of Test Coupon 09-06-01

Welder Barclay Elliott

Date of Test Coupon 09-06-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld